

Work Order ID 67811

Thursday, March 31, 2011 9:05:02 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4373-7

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Spacer

Start Date: 3/31/2011 Start Qty: 1.00



Cust Item ID:



Required Date: 4/1/2011 Req'd Qty: 1.00

Customer:

Reference:

11-03-31

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4373	PA1

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER DWG
DWG REV: PA1

DEBURR

J.F.S. 11/03/31

1 0 8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

J.F.S. 11/03/31

1 0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B 11.03.31

1 0

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop








Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0	11-03-31	
122 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	BK	11-3-31	
130 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							



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Revision ID: PRELIM Stop 
Item Name: Spacer
Start Date: 3/31/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/1/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL

EFFECTIVE 6/23/11 AUTH W

RELEASED _____ DATE _____

RD
1370MF
11-03-31

Picklist Print

Page 1

Thursday, March 31, 2011 9:04:58 AM

Work Order ID: 67811



Parent Item: D4373-7



Parent Item Name: Spacer

Start Date: 3/31/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV: A NEW ISSUE 11-03-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R2.000		Purchased	No			100	f	49.0000	0.05	0.052632			
6061T6 ROUND BAR 2.00													

Location

Loc Qty

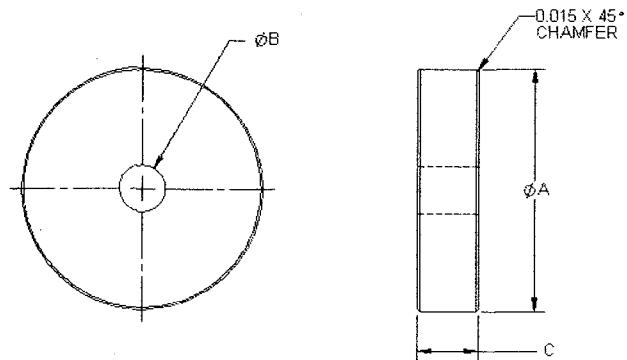
Loc Code

MAT013

49

17887

49



w/o 67811

D4373-Y

PART NUMBER	ØA	ØB	C
D4373-5	1.625	0.386	0.500
D4373-7	2.000	0.386	0.500

NOTES

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/6 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO. D4373	REV. PA1
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE FLOOR HARDWARE	SCALE NTS
DE APPR.		DATE 11.03.29	
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